

Date: Wednesday, 15/04/2009 9:48:55 AM
 User: Julie Dawson

Process Sheet

| | |
|---|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : WEARPLATE |
| Job Number : 47210 | |
| Estimate Number : 13309 | |
| P.O. Number : | Part Number : D37911 64 |
| This Issue : 15/04/2009 S.O. No. : | Drawing Number : D3791 REVA |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : SMALL /MED FAB | Drawing Revision : A |
| Previous Run : 45577 | Material : |
| Written By : | Due Date : 23/04/2009 Qty: 12 Um: Each |
| Checked & Approved By : <u>JUD 09.04.15</u> | |
| Comment : Est Rev:A 08-05-13 new issue DD verified by:EC Est Rev:B 08-05-22 revA as per dwg ECN1191 DD verified by:EC | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-----------|--------------------|
| 1.0 | M304S16GA | 304/316 Sheet .063 |
|-----|-----------|--------------------|



Comment: Qty.: 0.3063 sf(s)/Unit Total : 3.6754 sf(s)
 M304S16GA Stainless steel sheet 0.063" thick
 Batch: 111323 **IB 9-4-27**

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET
 1-Cut as per Dwg D3791
 Dwg Rev: A **IB 9-4-27**
 Prog Rev: L

(12)

2-Deburr if necessary **IB 9-4-27**

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

S 09/04/27 (12)

| | | |
|-----|----------|----------|
| 5.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE
 1-Deburr if necessary

2-Form on Brake as per Dwg D3791 using Jigs

S 09/05/01 (12)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 15/04/2009 9:48:56 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 47210

Part Number: D37911

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|-----|------------------------------|
| 6.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP
Ensure joggle as per dwg D3429

50/05/01 (12)

| | | |
|-----|-------------|------------------------------|
| 7.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|



Comment: 1-Weld hardcoat as per dwg D3791 QSI004

Hardcoat 2059b Batch: M111585

EL 9-5-5 (12)

| | | |
|-----|------|-----------------------------------|
| 8.0 | QC10 | VISUAL INSPECTION OF GROUND WELDS |
|-----|------|-----------------------------------|



Comment: VISUAL INSPECTION OF GROUND WELDS

50/05/05 (12)

| | | |
|-----|-----|------------------------------|
| 9.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

50/05/05 (12)

| | | |
|------|----------------|----------------|
| 10.0 | POWDER COATING | POWDER COATING |
|------|----------------|----------------|



Comment: POWDER COATING
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

8:10

OVEN TEMPERATURE:

320°

FINISH TIME:

8:40

FL 09/05/06 (12)

| | | |
|------|-----|---|
| 11.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
|------|-----|---|



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-05-6 (12)

| | | |
|------|-------------|-----------------------|
| 12.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|------|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify with Dart part # and batch # using a fine point permanent marker and Stock

Location: FP-17

FL 09/05/06 (12)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Date: Wednesday, 15/04/2009 9:48:56 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 47210

Part Number: D37911

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/06 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-05-06

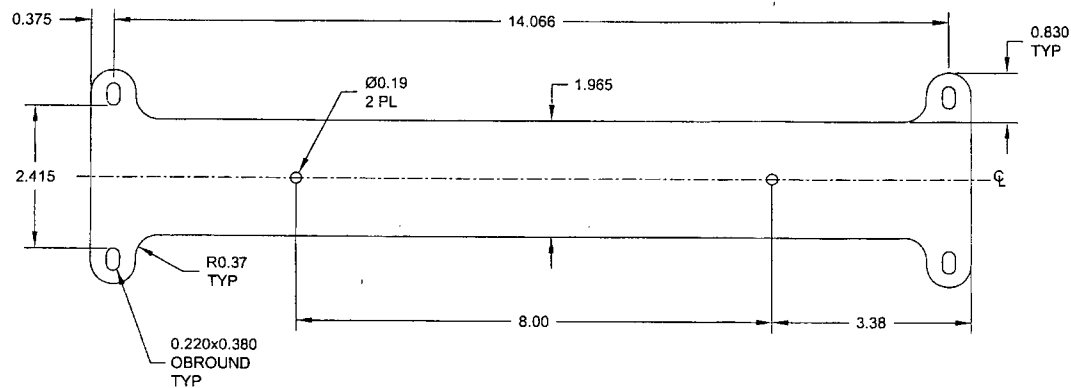
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

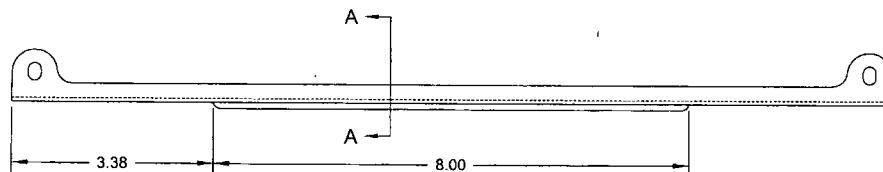
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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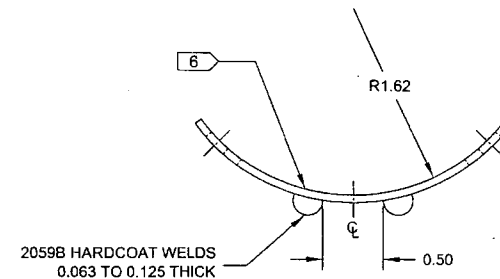
NOTE: Date & initial all entries



D3791-1F FLAT PATTERN



D3791-1 WEARPLATE
 (MAKE FROM D3791-1F)



SECTION A-A
 SCALE 2X

NO. 17210
 WORK ORDER
 WITHOUT NOTICE
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 ENGINEERING
 RETURN TO
 SHOP COPY

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
 (REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3791-1" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: 0.70 LBS
- 8) WELD PER DART QSI 004

RELEASED
 08-05-21/18

| REV. | NEW ISSUE | DESCRIPTION | PH | 08.05.13 |
|------------|-----------|---|--------------|----------|
| DESIGN | PH | DART AEROSPACE USA, INC PORT HADLOCK, WA | BY | DATE |
| DRAWN | PH | | | |
| CHECKED | | DRAWING NO. | REV. A | |
| MFG. APPR. | | D3791 | SHEET 1 OF 1 | |
| APPROVED | | TITLE | SCALE | |
| DE APPR. | | WEARPLATE | NTS | |
| DATE | 08.05.13 | COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC | | |